

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2015-50** Date Opened: **14 May 2015** Title: **Assembly**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350/355** Product Type: **Cargo Basket** Product Model: **XL Ski** Quantity: **4****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JR
JR

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
94010	0	Basket Assembly	JR

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

5
N/A
N/A
JR

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Tracking (White) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JR
N/A
N/A

**Traveller**

Initial or N/A


Work performed by:

Print: J Rekve for M Rekve

Sign:

ICC / Dual Inspection performed by:

Print: Jason Rekve

Sign:

Work Order closed by:

Print: Jason Rekve

Sign:

SCA: AD01

Date: 26-May-15

SCA: AD01

Date: 26-May-15

SCA: AD01

Date: 26-May-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

## CARGO BASKET BODY FABRICATION - COMMON

### General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

*Options* 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

#### **Eurocopter AS350/AS355** – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

→ 94011, Revision 0 – Extra Large (ski) Basket

*Options* 70406, Revision 2 – Front end cutout – 764/776/784/940

#### **Robinson R44** – left or right

90611, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

*Options* 70406, Revision 2 – Front end cutout – 802/803/811

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

*Options* 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options** – Applicable to all models

70403, Revision 5 – Auxiliary Latch



## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

Work Order: 2015-50

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AD06

### 1. Rim Assembly – Basket Body

- a. Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig.
  - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AD-05

### 2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

dk

### 3. Inspection

- a. Rim for complete welds

### 4. Frame assembly – body

AD06

- a. General
  - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
  - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
  - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
  - i. Ensure correct order and orientation of hoops. Refer to drawing.
    1. Attachment lugs are on inboard side.
    2. Handle bracket bushings are on outboard side, second hoop from both ends.  
May be on attachment hoops.
  - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
  - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
  - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
  - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut  $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut  $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
  - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut  $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut  $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
  - i. Extra large baskets
    - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim
  - ii. All other baskets
    - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim, except R44

### 5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

AD-05

### 6. Inspection

- a. Frame assembly for complete welds.

AD06

### 7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
  - i. For extra wide baskets only –
    - 1. Set  $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
    - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
    - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
  - ii. Using markings on table, align sheet to indicated edge.
  - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
  - iv. Bend mesh by hand tightly over tube along length of tube.
  - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
  - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

AD06



- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
  - i. General
    - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
    - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
    - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
    - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
  - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
  - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
  - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - v. Clamp mesh to spine in at least 1 place per section.
  - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
  - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
  - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh 1/4" down at 60 degrees.
  - iv. Fit mesh to front end of basket.

## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

AD-05

8. Weld mesh to frame assembly per drawing.
  - a. Ensure lug locating jig is in place prior to welding.
  - b. General welding requirements for all baskets, MIG welding:
    - i. Every intersection at top edges.
    - ii. Every intersection at ends.
    - iii. First 5 intersections down on hoops, then every second intersection.
    - iv. Every intersection along spine.
    - v. Extra large baskets – every intersection along corner.
    - vi. Every intersection around ends
    - vii. Every intersection along struts (if applicable)
  - c. Bend and trim cells bent in to fit mesh as required and weld in position.
  - d. Grind high spots off body mesh welds on ends before welding end mesh.
  - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
  - f. Record welding rod PO on attached material list.

### 9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
  - i. Record welding rod PO on attached material list.
  - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
  - i. Cut inboard rim on aft end. Grind flush with hoops.
  - ii. TIG weld caps on open tubes.
  - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
  - i. Record welding rod PO on attached material list.
  - ii. Record placard bracket WO on attached material list.

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### 10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AD-05

### 11. Final Inspection


To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
  - i. Hoops for height.
  - ii. Rim for width and length and alignment.
  - iii. Lid prop lugs in correct ends.
  - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

dk

**CARGO BASKET BODY FABRICATION - COMMON**

**Complete**  
(initial or SCA #)



- e. Tag complete basket body assembly in preparation for powder coating.

**12. Powder Coating**

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.



2015-50

## CARGO BASKET HOOP FABRICATION - 94023

### General

These instructions apply to cargo basket attachment hoop 94023-01. Refer to the following drawings, at the current revision, for dimensions and details:

94023, Revision 0 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

Work Order: 2015-50

**Complete**  
(initial or SCA #)

Date Open: 14 MAY 2015

Ana

#### 1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 23.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??"
  - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 18" (Outside to outside)
  - ii. adjust upper stop for height if required

#### 2. ½ Hoop Machining – ½" hoop – Handle Provisions 84262-01

Ana

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.



ADD

## 3. ½ Hoop Fabrication – 1" hoop

- a. Cut 1" x 0.065 material to 30.0", on end square, one end @ 16 degrees.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??
  - ii. Lower bend stop: ??
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle using hoop jig. Adjust stops if required.
- j. Check for:
  - i. hoop height from jig
  - ii. adjust upper stop for height if required
  - iii. length to allow 60 degree cut.
- k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- l. De-burr cut end using a sanding disc on a die-grinder or disc sander.

## 4. ½ Hoop Machining – 1" hoop

ADD

- a. Start with 1" ½ hoop as stock.
- b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0. Shift Y -0.5". Set stop against end of tube.
- c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Set tube in vise with 60 degree end on right.
- f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- h. Tag in process hoop(s) and place into stock.

## 5. Joint Preparation

ADD

- a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.
- b. Insert one 94023-05 lug (flat end) at top and 94023-07 lug (angled end) at bottom into holes in 1" hoop. Seat top lug flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop. Mark 94023-07 lug and trim or grind to fit.

AD-05 ~~AD-05~~ *AD-05*

## 6. Welding – Lugs

- a. Insert one 94023-07 lug (flat end) at top and 94023-05 lug (angled end) at bottom into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop.
- b. TIG weld all around both sides of lugs. 2 places. Grind angled lug into radius of hoop before welding.
- c. Record lug and welding rod PO/WO on attached material list.

## 7. Welding – Handle Bushings – 84262-01

AD-05

- a. Insert 84271-01 bushings into 1/2" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

## 8. Welding – Hoop Assembly

AD-05

- a. Insert 1" hoop from step 6 and 1/2" hoop from step 7 into hoop jig. Seat 1/2" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around 1/2" hoop in slot.
- d. Cap 1/2" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

## 9. Finishing and Inspection

*OK*

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.



## 1" Hoop Bend

Requirements
*Review LOED to ensure most up to date specifications.
* Cut 33 3/8.
*Cut one end at 16 degrees and the other at 60 degrees.
* At the 16 degree end measure up 21 1/8 and mark.
* Line up the mark on the radius of the bender and bend.

CARGO BASKET HOOP FABRICATION - 76421

THIS IS FOR MEDIUM / LONG

General

ADD NOTES FOR XL

These instructions apply to cargo basket hoop 76421-01 and derivatives that use it as stock. Refer to the following drawings, at the current revision, for dimensions and details:

76421, Revision 0 – Hoop

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2015-50

Complete  
(initial or SCA #)

Date Open: 14 May 15

ADD

1. Hoop Fabrication

- a. Cut  $\frac{1}{2}$ " x 0.035 material to 48.0"?, one end square, one end @ 16 degrees.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??"
  - ii. Lower bend stop: ??
- f. Slide stock tube through bending die up to upper stop, angled end of tube, long side away. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die.
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle and height using hoop jig. Adjust stops if required.
- j. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??"
  - ii. Lower bend stop: 12mm
- k. Slide stock tube through bending die up to upper stop, square end of tube. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- l. Slide shim all the way forward on bender to secure tube in die.
- m. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- n. Check tube bend for square and height using hoop jig or carpenters square. Adjust stops if required.
- o. Check for:
  - i. hoop height: 17  $\frac{1}{8}$ " (Outside to outside)
  - ii. hoop width at top: 21" (inside to inside)
  - iii. adjust upper stop for height if required
  - iv. adjust stock length for width if required
  - v. twist – due to pulling bending arm up or down through bend



• CARGO BASKET HOOP FABRICATION - 76421

- - p. Drill #30 vent holes in bottom centre of hoop in fore/aft direction. De-burr with scotch-brite disc on die-grinder.
  - q. Inspect hoops for conformity to drawing.
  - r. Tag complete and inspected hoop(s) and place into stock.



WO# 2015-50

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



Work Order: 2015-50

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Hoops Fabrication

1 of 1

Date Opened: 14 MAY 2015

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	2015-26 / Po#14099
			94023-01	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	.1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	14083
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	.1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	15015
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	.1		94023-05	Stud	1018 Mild Steel, 5/8" Dia.	
	.1		94023-07	Stud	1018 Mild Steel, 5/8" Dia.	
Step 7	.2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	2014-15 / 2014-26 (ss)
Step 8	.1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	9010
	A/R		--	Welding Rod	ER70S-2	14033
Step 9				Finishing and Inspection	None	

Work Order: 2015-50Date Opened: 14 MAY 2015

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<del>5</del> <u>4</u>	94011	94011-01	<b>Basket Assembly</b>		
<b>Step 1</b>				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	1211
<b>Step 2</b>				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
<b>Step 3</b>				<i>Inspection - Rim</i>	None	
<b>Step 4</b>				<i>Frame Assembly</i>		
	. 4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	2015-26 / 14099
	. 2		94023-01	Hoop - attachment		
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
<b>Step 4.g.</b>		70406	70406-01	<i>Option: Front End Cutout</i>		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
<b>Step 5</b>				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
<b>Step 6</b>				<i>Inspection - Frame Assembly</i>	None	
<b>Step 7</b>				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	14012
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	14012

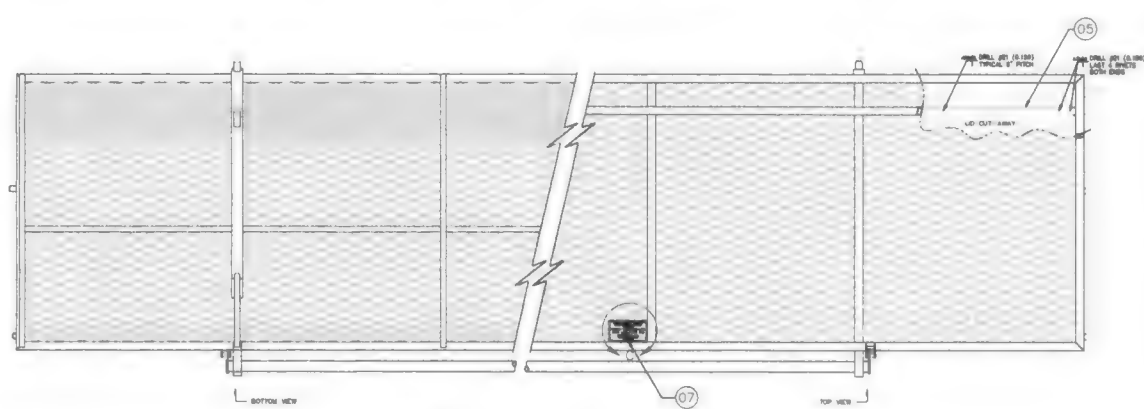
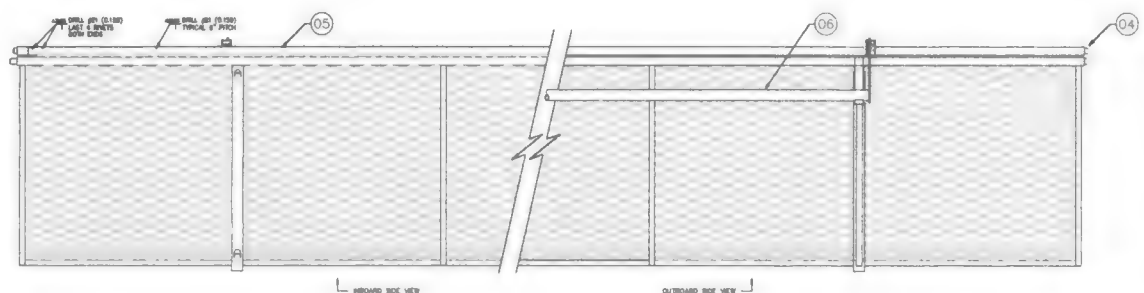


Work Order: 2015-50Date Opened: 14 MAY 2015Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Body Fabrication

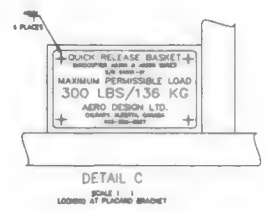
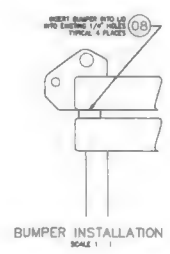
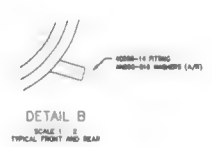
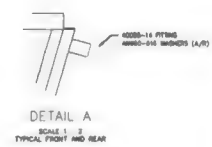
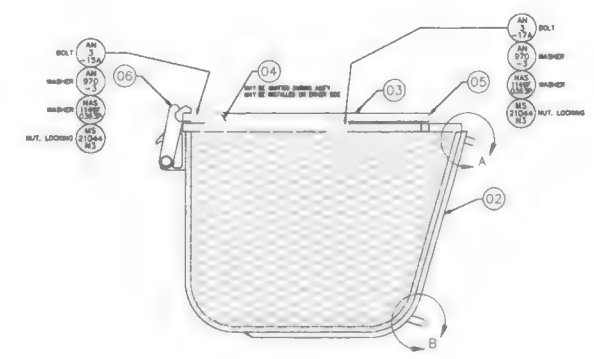
2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 8</b>				<i>Weld Mesh</i>		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	14028
<b>Step 9</b>				<i>Weld Basket Components</i>		
	2		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	2014-38
	A/R		--	Welding Rod	ER308L TIG Rod	14028
<b>Step 10</b>				<i>Clean Up</i>	None	
<b>Step 11</b>				<i>Inspection - Final Assembly</i>	None	
<b>Step 12</b>				<i>Powder Coating</i>		

REV	DESCRIPTION OF CHANGE	DETAILS	DATE
1	INITIAL ISSUE		



94010  
101 CARGO BASKET ASSEMBLY - RH



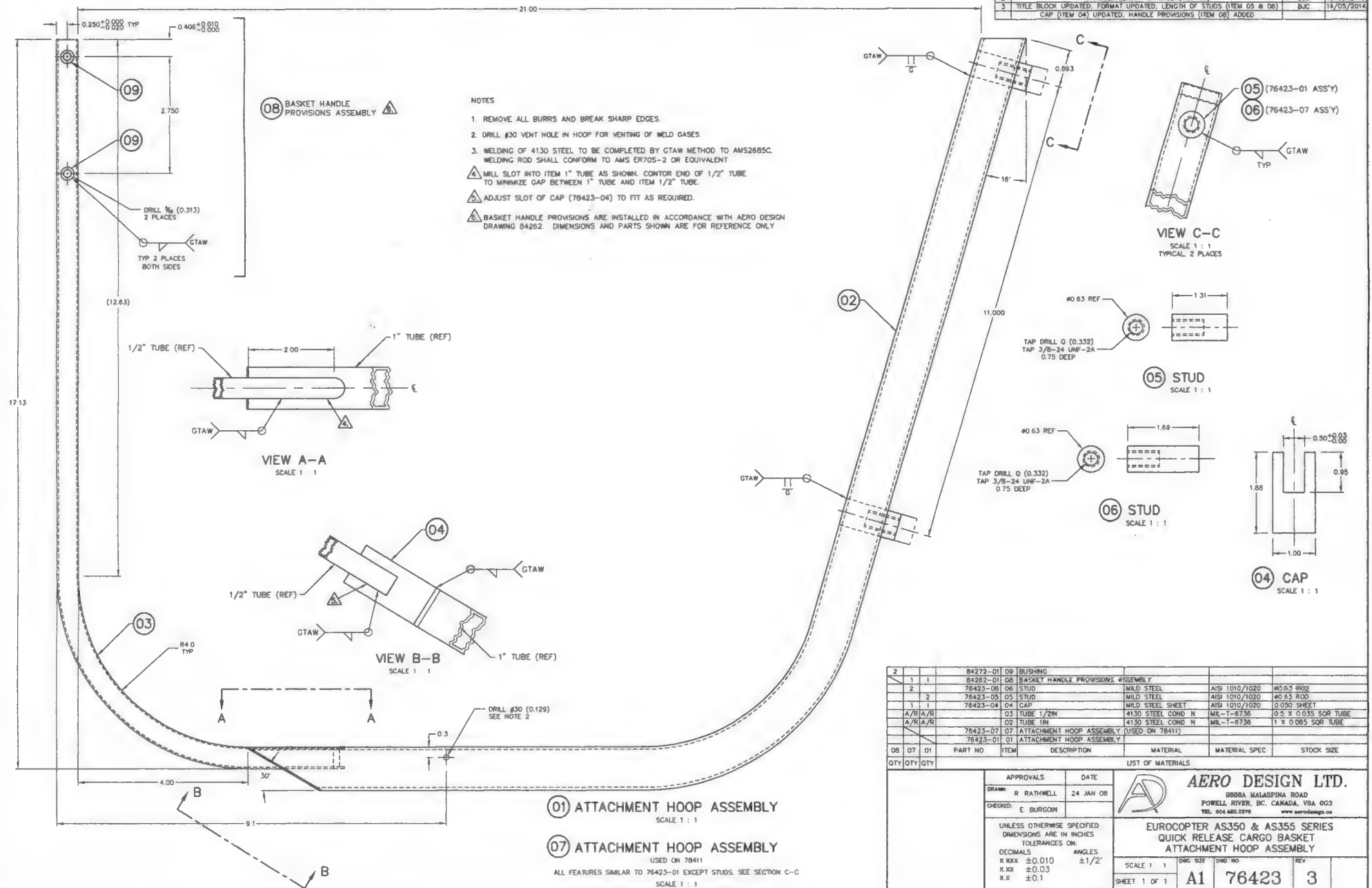
NOTE:  
1. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

QTY	PART NO.	DESC	MATERIAL	MATERIAL SPEC.	STOCK SIZE
1	94010-101	CARGO BASKET ASSEMBLY - RH			
1	94010-102	CARGO BASKET ASSEMBLY - LH			
1	94010-103	CARGO BASKET ASSEMBLY - FWD			
1	94010-104	CARGO BASKET ASSEMBLY - AFT			
1	94010-105	CARGO BASKET ASSEMBLY - L/R			
1	94010-106	CARGO BASKET ASSEMBLY - R/L			
1	94010-107	CARGO BASKET ASSEMBLY - FWD			
1	94010-108	CARGO BASKET ASSEMBLY - AFT			
1	94010-109	CARGO BASKET ASSEMBLY - L/R			
1	94010-110	CARGO BASKET ASSEMBLY - R/L			
1	94010-111	CARGO BASKET ASSEMBLY - FWD			
1	94010-112	CARGO BASKET ASSEMBLY - AFT			
1	94010-113	CARGO BASKET ASSEMBLY - L/R			
1	94010-114	CARGO BASKET ASSEMBLY - R/L			
1	94010-115	CARGO BASKET ASSEMBLY - FWD			
1	94010-116	CARGO BASKET ASSEMBLY - AFT			
1	94010-117	CARGO BASKET ASSEMBLY - L/R			
1	94010-118	CARGO BASKET ASSEMBLY - R/L			
1	94010-119	CARGO BASKET ASSEMBLY - FWD			
1	94010-120	CARGO BASKET ASSEMBLY - AFT			
1	94010-121	CARGO BASKET ASSEMBLY - L/R			
1	94010-122	CARGO BASKET ASSEMBLY - R/L			
1	94010-123	CARGO BASKET ASSEMBLY - FWD			
1	94010-124	CARGO BASKET ASSEMBLY - AFT			
1	94010-125	CARGO BASKET ASSEMBLY - L/R			
1	94010-126	CARGO BASKET ASSEMBLY - R/L			
1	94010-127	CARGO BASKET ASSEMBLY - FWD			
1	94010-128	CARGO BASKET ASSEMBLY - AFT			
1	94010-129	CARGO BASKET ASSEMBLY - L/R			
1	94010-130	CARGO BASKET ASSEMBLY - R/L			
1	94010-131	CARGO BASKET ASSEMBLY - FWD			
1	94010-132	CARGO BASKET ASSEMBLY - AFT			
1	94010-133	CARGO BASKET ASSEMBLY - L/R			
1	94010-134	CARGO BASKET ASSEMBLY - R/L			
1	94010-135	CARGO BASKET ASSEMBLY - FWD			
1	94010-136	CARGO BASKET ASSEMBLY - AFT			
1	94010-137	CARGO BASKET ASSEMBLY - L/R			
1	94010-138	CARGO BASKET ASSEMBLY - R/L			
1	94010-139	CARGO BASKET ASSEMBLY - FWD			
1	94010-140	CARGO BASKET ASSEMBLY - AFT			
1	94010-141	CARGO BASKET ASSEMBLY - L/R			
1	94010-142	CARGO BASKET ASSEMBLY - R/L			
1	94010-143	CARGO BASKET ASSEMBLY - FWD			
1	94010-144	CARGO BASKET ASSEMBLY - AFT			
1	94010-145	CARGO BASKET ASSEMBLY - L/R			
1	94010-146	CARGO BASKET ASSEMBLY - R/L			
1	94010-147	CARGO BASKET ASSEMBLY - FWD			
1	94010-148	CARGO BASKET ASSEMBLY - AFT			
1	94010-149	CARGO BASKET ASSEMBLY - L/R			
1	94010-150	CARGO BASKET ASSEMBLY - R/L			
1	94010-151	CARGO BASKET ASSEMBLY - FWD			
1	94010-152	CARGO BASKET ASSEMBLY - AFT			
1	94010-153	CARGO BASKET ASSEMBLY - L/R			
1	94010-154	CARGO BASKET ASSEMBLY - R/L			
1	94010-155	CARGO BASKET ASSEMBLY - FWD			
1	94010-156	CARGO BASKET ASSEMBLY - AFT			
1	94010-157	CARGO BASKET ASSEMBLY - L/R			
1	94010-158	CARGO BASKET ASSEMBLY - R/L			
1	94010-159	CARGO BASKET ASSEMBLY - FWD			
1	94010-160	CARGO BASKET ASSEMBLY - AFT			
1	94010-161	CARGO BASKET ASSEMBLY - L/R			
1	94010-162	CARGO BASKET ASSEMBLY - R/L			
1	94010-163	CARGO BASKET ASSEMBLY - FWD			
1	94010-164	CARGO BASKET ASSEMBLY - AFT			
1	94010-165	CARGO BASKET ASSEMBLY - L/R			
1	94010-166	CARGO BASKET ASSEMBLY - R/L			
1	94010-167	CARGO BASKET ASSEMBLY - FWD			
1	94010-168	CARGO BASKET ASSEMBLY - AFT			
1	94010-169	CARGO BASKET ASSEMBLY - L/R			
1	94010-170	CARGO BASKET ASSEMBLY - R/L			
1	94010-171	CARGO BASKET ASSEMBLY - FWD			
1	94010-172	CARGO BASKET ASSEMBLY - AFT			
1	94010-173	CARGO BASKET ASSEMBLY - L/R			
1	94010-174	CARGO BASKET ASSEMBLY - R/L			
1	94010-175	CARGO BASKET ASSEMBLY - FWD			
1	94010-176	CARGO BASKET ASSEMBLY - AFT			
1	94010-177	CARGO BASKET ASSEMBLY - L/R			
1	94010-178	CARGO BASKET ASSEMBLY - R/L			
1	94010-179	CARGO BASKET ASSEMBLY - FWD			
1	94010-180	CARGO BASKET ASSEMBLY - AFT			
1	94010-181	CARGO BASKET ASSEMBLY - L/R			
1	94010-182	CARGO BASKET ASSEMBLY - R/L			
1	94010-183	CARGO BASKET ASSEMBLY - FWD			
1	94010-184	CARGO BASKET ASSEMBLY - AFT			
1	94010-185	CARGO BASKET ASSEMBLY - L/R			
1	94010-186	CARGO BASKET ASSEMBLY - R/L			
1	94010-187	CARGO BASKET ASSEMBLY - FWD			
1	94010-188	CARGO BASKET ASSEMBLY - AFT			
1	94010-189	CARGO BASKET ASSEMBLY - L/R			
1	94010-190	CARGO BASKET ASSEMBLY - R/L			
1	94010-191	CARGO BASKET ASSEMBLY - FWD			
1	94010-192	CARGO BASKET ASSEMBLY - AFT			
1	94010-193	CARGO BASKET ASSEMBLY - L/R			
1	94010-194	CARGO BASKET ASSEMBLY - R/L			
1	94010-195	CARGO BASKET ASSEMBLY - FWD			
1	94010-196	CARGO BASKET ASSEMBLY - AFT			
1	94010-197	CARGO BASKET ASSEMBLY - L/R			
1	94010-198	CARGO BASKET ASSEMBLY - R/L			
1	94010-199	CARGO BASKET ASSEMBLY - FWD			
1	94010-200	CARGO BASKET ASSEMBLY - AFT			

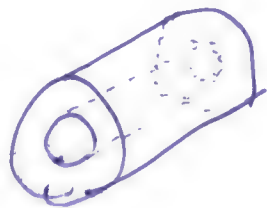
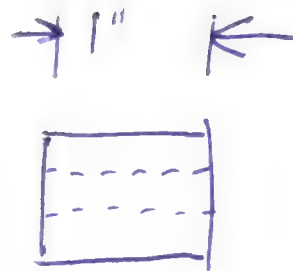
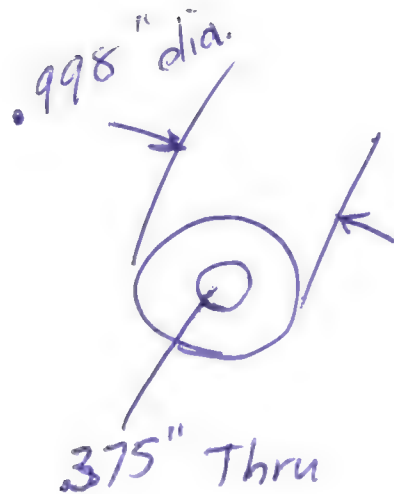
AERO DESIGN LTD.  
QUICK RELEASE CARGO BASKET  
CARGO BASKET ASSEMBLY  
SCALE 1:4  
SHEET 1 OF 1  
A0 94010 0

AS350 MED / LONG  
AFT BOTH

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
	1. INITIAL ISSUE	HS	24 JAN 08
1	ADDED 76423-07 ASSY AND 76423-06 PART	RR	05 MAR 09
2	CHANGED LENGTH OF STUD (ITEM 05)	SJC	16 JUN 10
3	TITLE BLOCK UPDATED, FORMAT UPDATED, LENGTH OF STUDS (ITEM 05 & 06) CAP (ITEM 04) UPDATED, HANDLE PROVISIONS (ITEM 06) ADDED	SJC	18/05/2014

[illegible]





4 of




407 NO CUT OUT  
w/ walkway

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	WYLE BLOCK UPDATED; VEIN HOLE ADDED, NOTE 2 REMOVED, 3 MOVED TO 2	BWC	11/07/2014

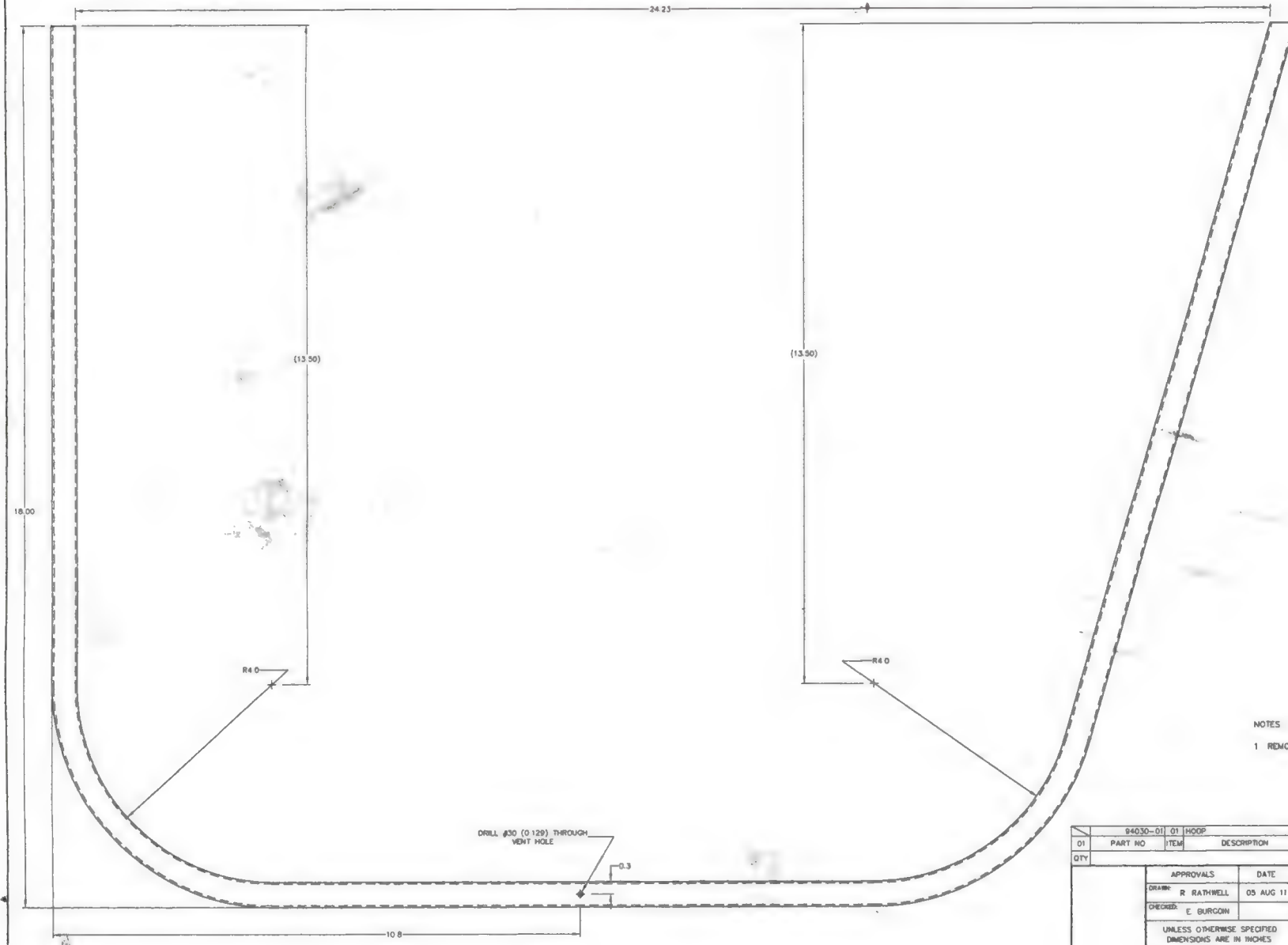


1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2683C. WELDING ROD SHALL CONFORM TO AMS E70S-2 OR EQUIVALENT.


2	69823-02	03	LUG				
1	76421-01	02	HOOP				
01	76422-01	01	ATTACHMENT HOOP ASSEMBLY				
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	LIST OF MATERIALS						
APPROVALS DRAWN: R RATHWELL CHECKED: E BURGON 24 JAN 06				 <b>AERO DESIGN LTD.</b> 6886A MALASPINA ROAD POWELL RIVER, BC, CANADA V8A 0G3 TEL. 604.692.9276 <a href="http://www.aero-design.ca">www.aero-design.ca</a>			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES OR DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1				EUROCOPTER AS350 &AS355 SERIES QUICK RELEASE CARGO BASKET ATTACHMENT HOOP ASSEMBLY			
SCALE 1 : 1 SHEET 1 OF 1				DRG SIZE DRG NO REV <b>A1</b> <b>76422</b> <b>1</b>			

~~7/8~~ cut 52 7/8  
 13 3/4  
 15 3/16  
 Bend Bend

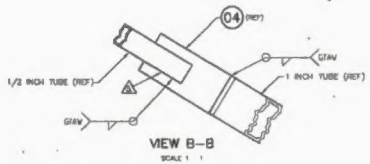
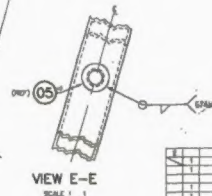
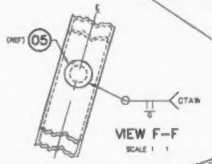
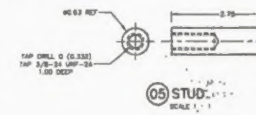
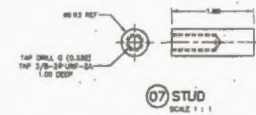
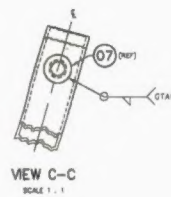
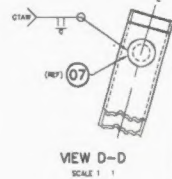
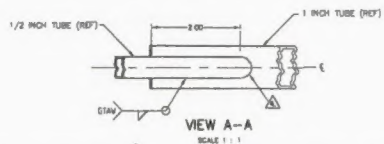
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR TRANSMITTED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR INSPECTION THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED, DRAWING REFORMATTED TO A1	BUC	11/07/2014



NOTES  
 1. REMOVE ALL BURRS AND BREAK SHARP EDGES

94030-01		01	HOOP	4130 STEEL COND N	MIL-T-8736	0.5 X 0.035 SQR TUBE						
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE						
QTY				LIST OF MATERIALS								
<table><tr><td>APPROVALS</td><td>DATE</td></tr><tr><td>DRAWN: R. RATHWELL</td><td>05 AUG 11</td></tr><tr><td>CHECKED: E. BURGON</td><td></td></tr></table>				APPROVALS	DATE	DRAWN: R. RATHWELL	05 AUG 11	CHECKED: E. BURGON		<div><b>AERO DESIGN LTD.</b> 9906A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 250-480-5976 <a href="http://www.aerodesign.ca">www.aerodesign.ca</a></div>		
APPROVALS	DATE											
DRAWN: R. RATHWELL	05 AUG 11											
CHECKED: E. BURGON												
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:				EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET HOOP								
DECIMALS		ANGLES		SCALE 1:1	DWG SIZE	DWG NO						
X.100 ±0.010		±1/2°		SHEET 1 OF 1	A1	94030						
X.125 ±0.03												
X.1 ±0.1												
					REV	1						





① ATTACHMENT HOOP ASSEMBLY

- 1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
- 2. (REMOVED)
- 3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO ANS/ASME. WELDING ROD SHALL CONFORM TO AWS D107S-2 OR EQUIVALENT
- 4. MOUNT SLOTT INTO 1" TUBE AS SHOWN. CENTER END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND ITEM 1/2" TUBE.
- 5. ADJUST SLOT OF CAP (784243-04) TO FIT AS REQUIRED.
- 6. CUT AWAY PORTION OF STUD (SH063-05) FLUSH TO INSIDE SURFACE OF 1" TUBE AS SHOWN.
- 7. BARRIER HANDLE PROVISIONS ARE INSTALLED IN ACCORDANCE WITH AERO DESIGN

[illegible]

1" hoop bend instructions

Cut  $3\frac{3}{8}$

$2\frac{1}{8}$



line up mark on radius of bender.







